



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5551-3
Job Sheet 170807



Part No: D5551-3

Job Qty: 12 ea

Part Name: Aft Support Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D5551 REV.A IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/24/18	0.00	0.00	Start Up Waterjet		SC 18/02/05
100	Waterjet	12 pcs		2/26/18	0.00	4.60	Waterjet1		SC 18/02/05
110	QC	12 pcs		2/26/18	0.00	0.00	QC2 Waterjet-4		SC 18/02/05
120	QC	12 pcs		2/26/18	0.00	0.00	QC8-6		38
130	Packaging	12 pcs		2/26/18	0.00	0.00	Packaging3		9-88
140	QC21-SA	12 Ea		2/26/18	0.00	0.00	QC21		FEB 13 2018
Part Op Descriptions: 100 - 1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary									DAS 21 9-88 FEB 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	3.9960 sf (.333 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/19/18 1:19 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part: _____ NC _____ Date: _____ S040511 Aft Support Plate PART NO: D5551 – 3 Original Serial #: S040511 Revision: Operation: Start up Operation Change No:	DISPOSITION Rework ☐ Skid-tube ☐	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Cross tube ☐</td> <td style="width: 33%;">Water Jet ☐</td> <td style="width: 33%;">Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 80%; border: 1px solid black; height: 40px; vertical-align: bottom;">Disposition</td> <td style="width: 20%; border: 1px solid black; text-align: center;">MRB (QSI042) Approval</td> </tr> <tr> <td style="border: 1px solid black; height: 40px;"></td> <td style="border: 1px solid black; text-align: center;">Completed By</td> </tr> <tr> <td style="border: 1px solid black; height: 40px;"></td> <td style="border: 1px solid black; text-align: center;">Lead hand / Supervisor Approval Verification</td> </tr> <tr> <td style="border: 1px solid black; height: 40px;"></td> <td style="border: 1px solid black; text-align: center;">QC / QA Coordinator Approval</td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐		Disposition	MRB (QSI042) Approval		Completed By		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval
Cross tube ☐	Water Jet ☐	Engineering ☐																				
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Composite ☐	Supplier ☐																					
Disposition	MRB (QSI042) Approval																					
	Completed By																					
	Lead hand / Supervisor Approval Verification																					
	QC / QA Coordinator Approval																					
<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%; vertical-align: top;"> ENVIRONMENT Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐ </td> <td style="width: 33%; vertical-align: top;"> DEFECTS Bending ☐ Set-up ☐ Centre Not Concentric ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Cuffs ☐ Contamination ☐ Crushing ☐ Countersink ☐ Heat Treat ☐ Cut Too Short ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Marks/Chatter ☐ Drill Holes ☐ </td> <td style="width: 33%; vertical-align: top;"> CATEGORY ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Folio/Program ☐ Outside Dimensions ☐ Grain ☐ Over/Under tolerance ☐ Weld ☐ Part Incorrect ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Out of Sequence ☐ Part Moved ☐ Off-set ☐ Drawing ☐ Misabeled ☐ Finish ☐ Fit/Function ☐ Misread ☐ Misaligned/off center ☐ Turning Sequence </td> </tr> <tr> <td colspan="3" style="border: 1px solid black; height: 40px; vertical-align: bottom;">OTHER :</td> </tr> </table>			ENVIRONMENT Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐	DEFECTS Bending ☐ Set-up ☐ Centre Not Concentric ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Cuffs ☐ Contamination ☐ Crushing ☐ Countersink ☐ Heat Treat ☐ Cut Too Short ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Marks/Chatter ☐ Drill Holes ☐	CATEGORY ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Folio/Program ☐ Outside Dimensions ☐ Grain ☐ Over/Under tolerance ☐ Weld ☐ Part Incorrect ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Out of Sequence ☐ Part Moved ☐ Off-set ☐ Drawing ☐ Misabeled ☐ Finish ☐ Fit/Function ☐ Misread ☐ Misaligned/off center ☐ Turning Sequence	OTHER :																
ENVIRONMENT Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐	DEFECTS Bending ☐ Set-up ☐ Centre Not Concentric ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Cuffs ☐ Contamination ☐ Crushing ☐ Countersink ☐ Heat Treat ☐ Cut Too Short ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Marks/Chatter ☐ Drill Holes ☐	CATEGORY ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Folio/Program ☐ Outside Dimensions ☐ Grain ☐ Over/Under tolerance ☐ Weld ☐ Part Incorrect ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Out of Sequence ☐ Part Moved ☐ Off-set ☐ Drawing ☐ Misabeled ☐ Finish ☐ Fit/Function ☐ Misread ☐ Misaligned/off center ☐ Turning Sequence																				
OTHER :																						

DART AEROSPACE LTD		Work Order: 170807
Description: AFT support plate		Part Number: D5551-3
Inspection Dwg: D5551	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0,129	+0,005-0,001	Ø0,130	1		VPC02	
Ø0,191	+0,005-0,001	Ø0,192	1			
Ø0,250	+0,005-0,001	Ø0,250	1			
3,50	+/- 0,030	3,503	1			
6,01	+/- 0,030	6,015	1			
Ø0,50	+0,006-0,001	Ø0,501	1			
6,47	+/- 0,030	6,4715	1			
7,52	+/- 0,030	7,523	1			
6,62	+/- 0,030	6,626	1			
7,80	+/- 0,030	7,805	1			
7,89	+/- 0,030	7,892	1			
0,125	+/- 0,010	0,115	1			
2,300	+/- 0,010	2,301	1			
1,500	+/- 0,010	1,502	1			
3,000	+/- 0,010	3,000	1			
1,300	+/- 0,010	1,301	1			
0,60	+/- 0,030	0,604	1			
0,650	+/- 0,010	0,652	1			

Measured by: SC	Audited by:	Preliminary Approval:
Date: 18/02/05	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	